

FIG. 1

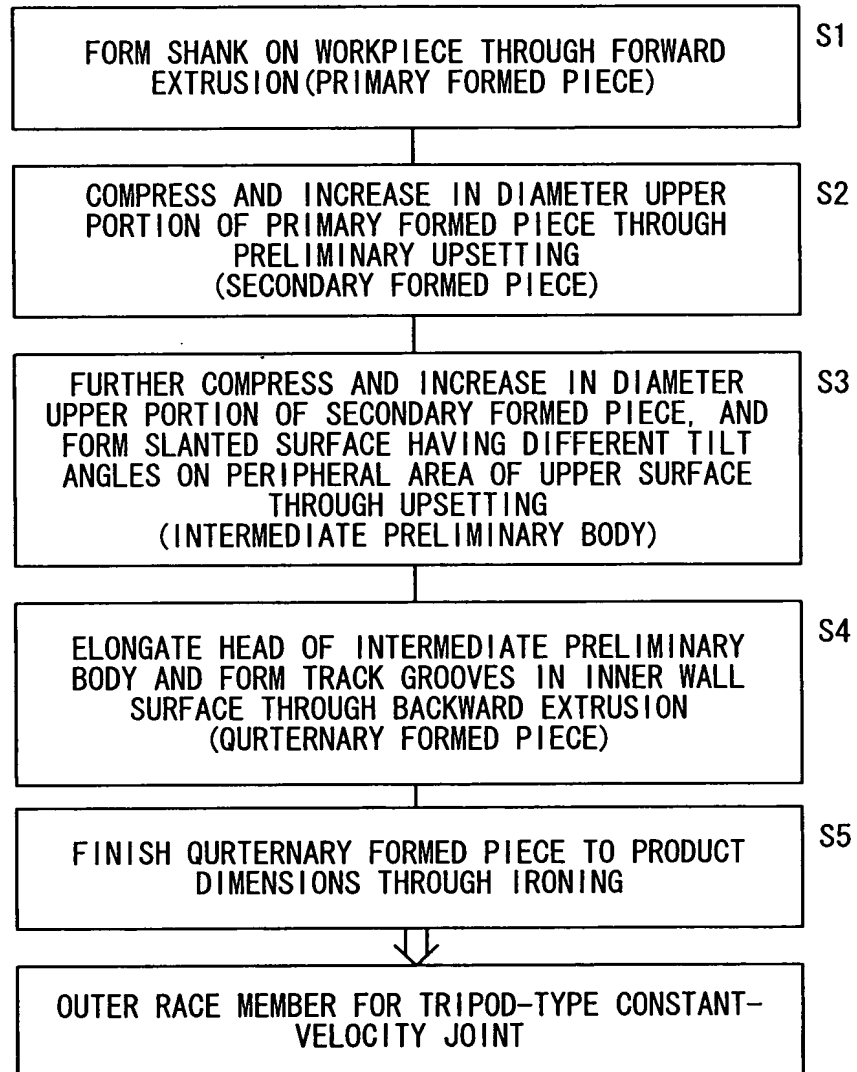
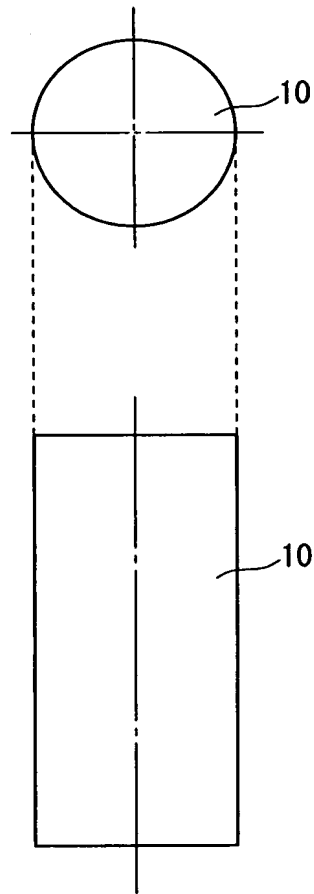
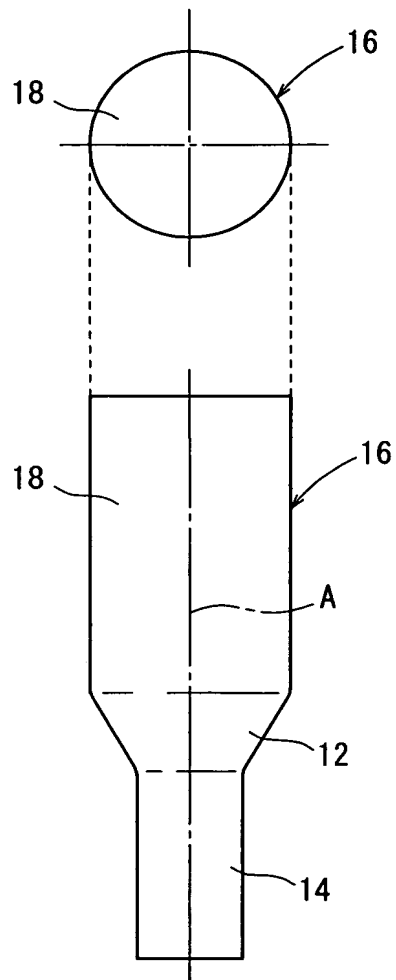


FIG. 2



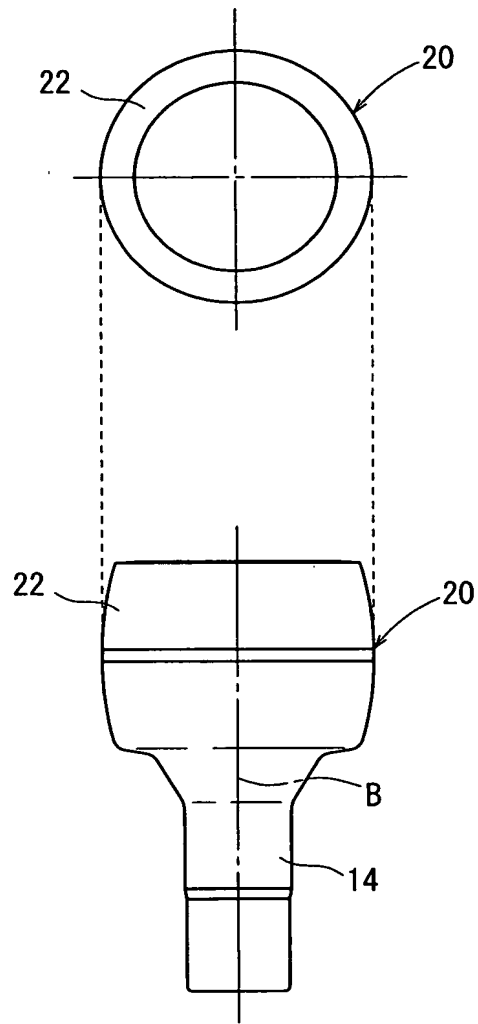
(WORKPIECE)

FIG. 3



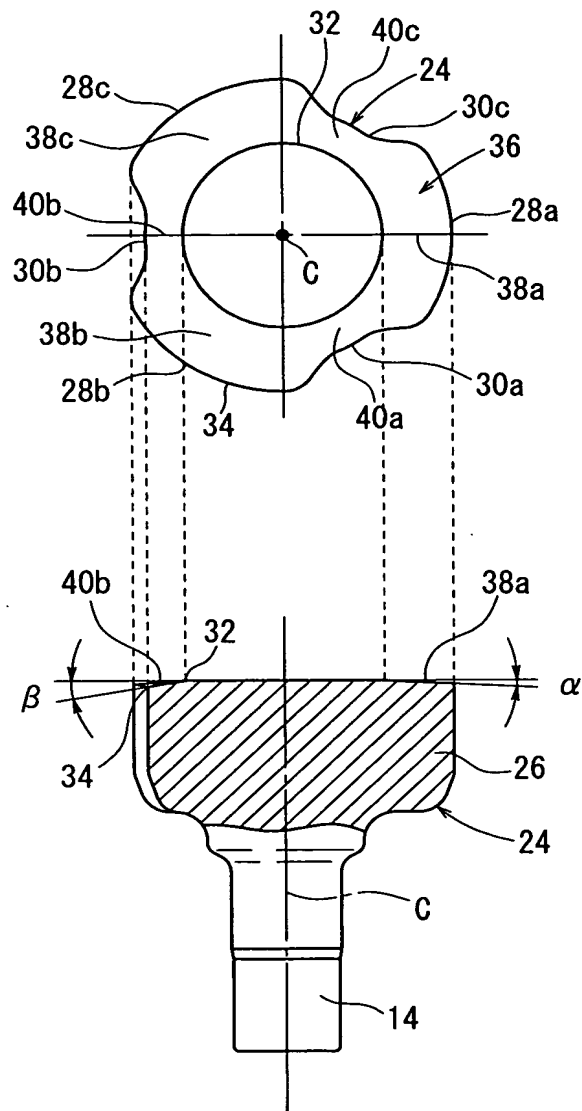
(PRIMARY FORMED PIECE)

FIG. 4



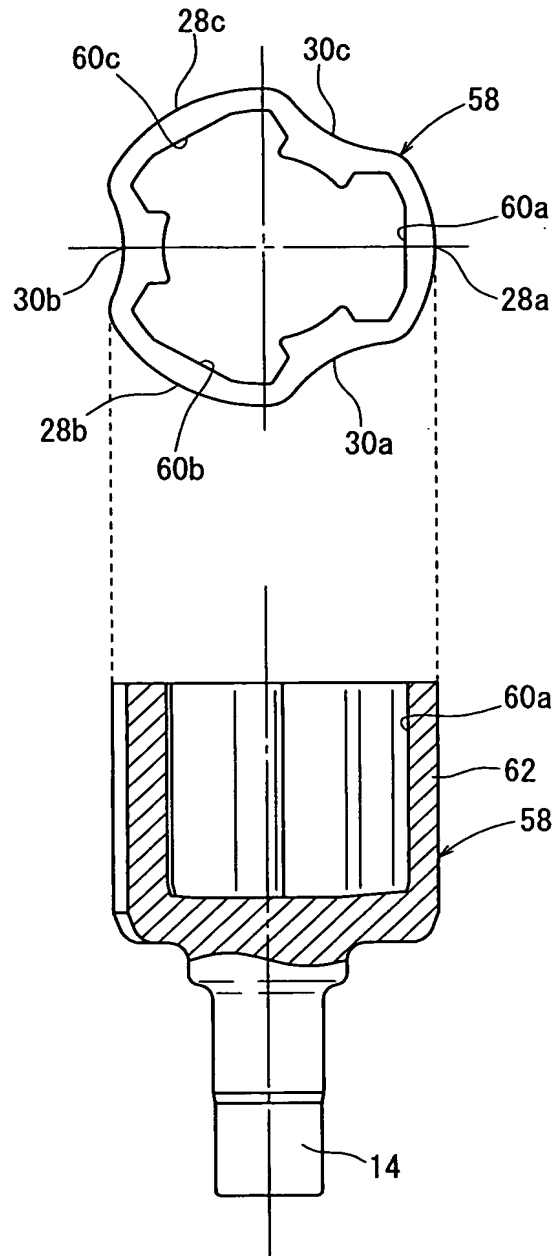
(SECONDARY FORMED PIECE)

FIG. 5



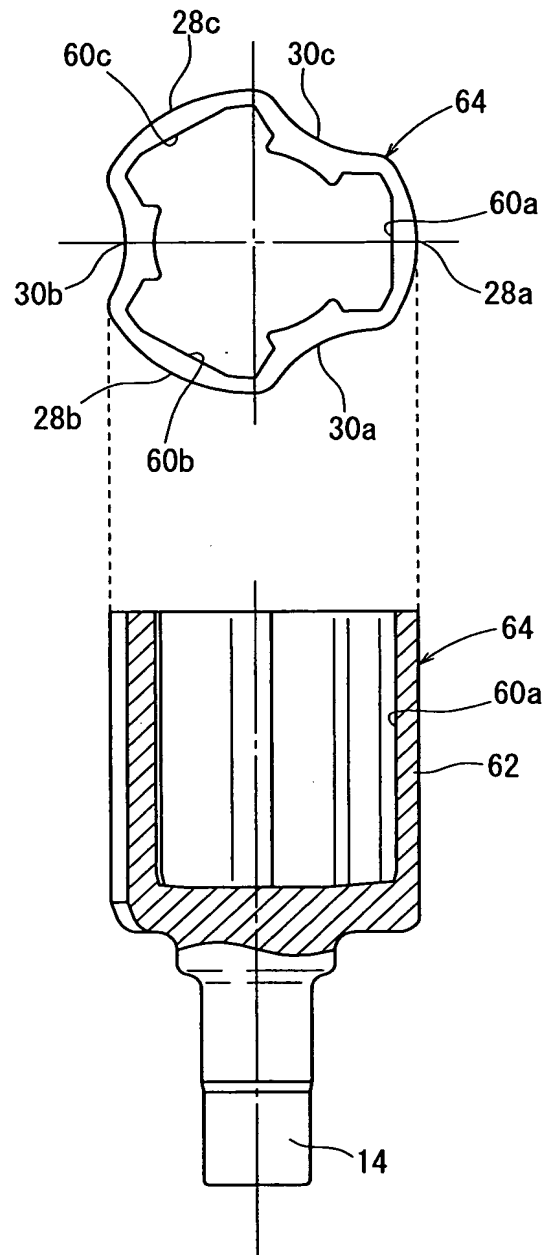
(INTERMEDIATE PRELIMINARY BODY)

FIG. 6



(QURTERNARY FORMED PIECE)

FIG. 7



(COMPLETED PRODUCT)

FIG. 8

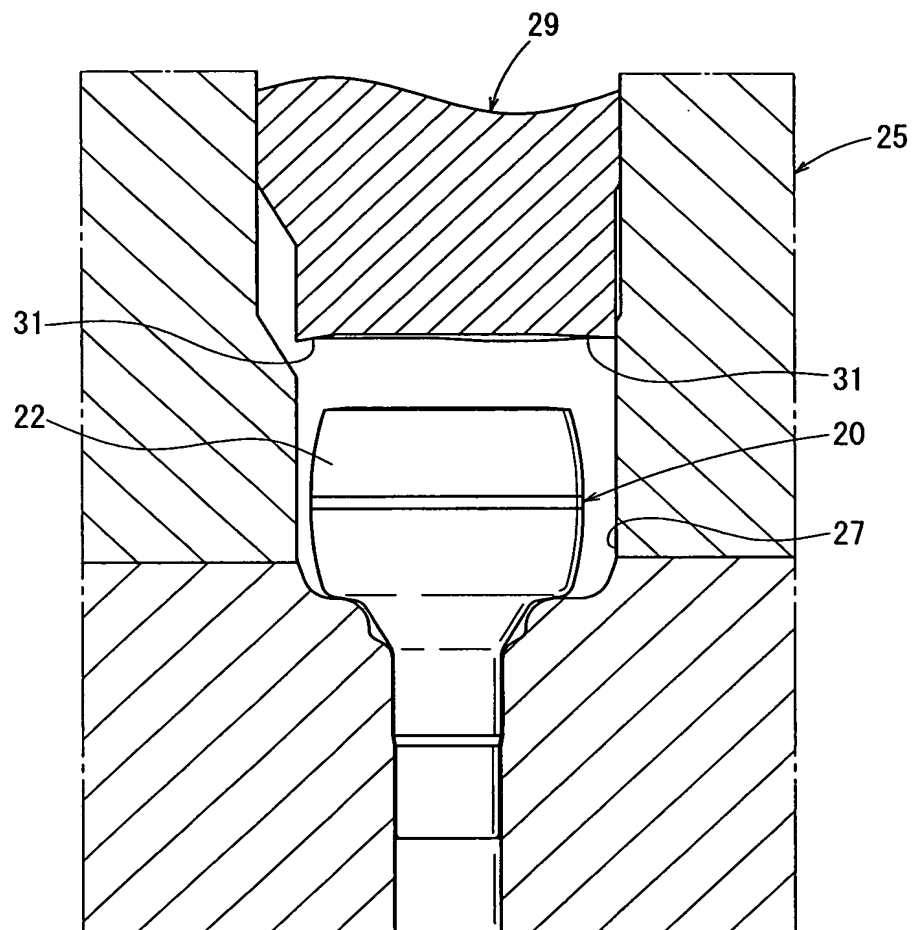


FIG. 9

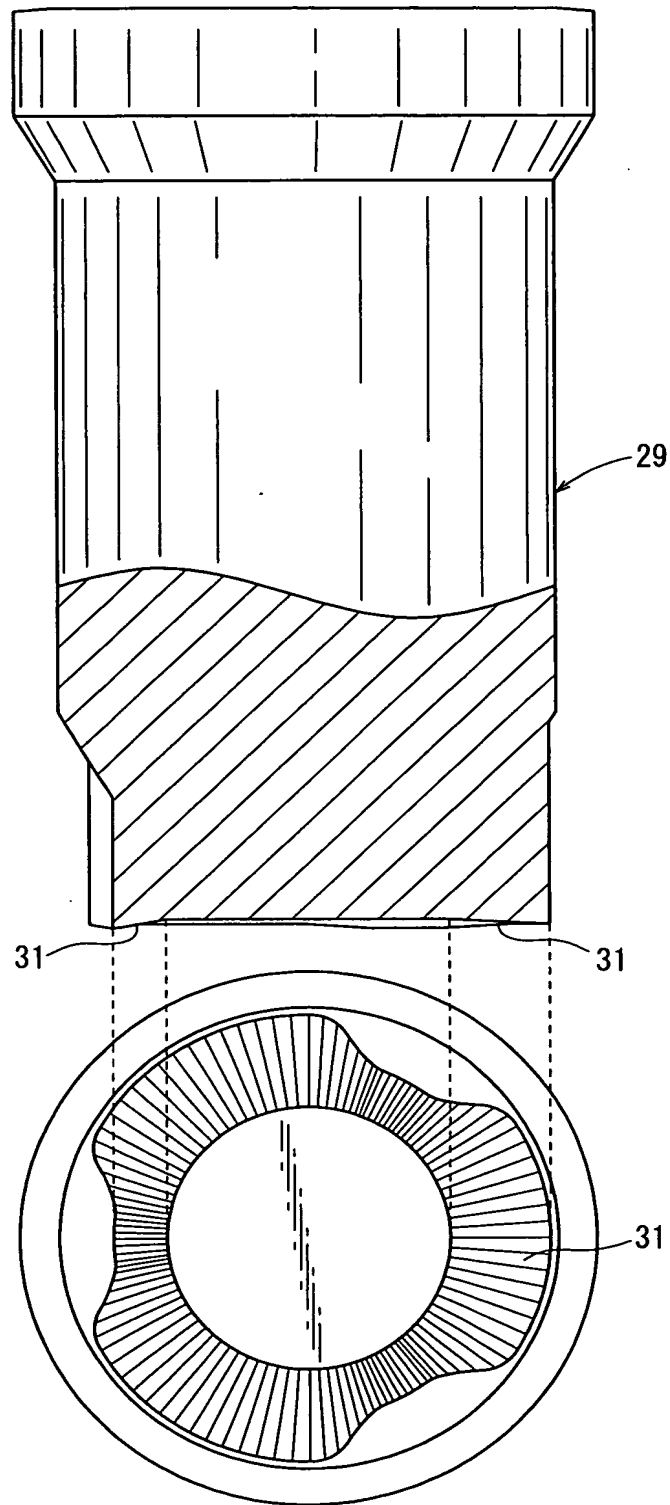


FIG. 10

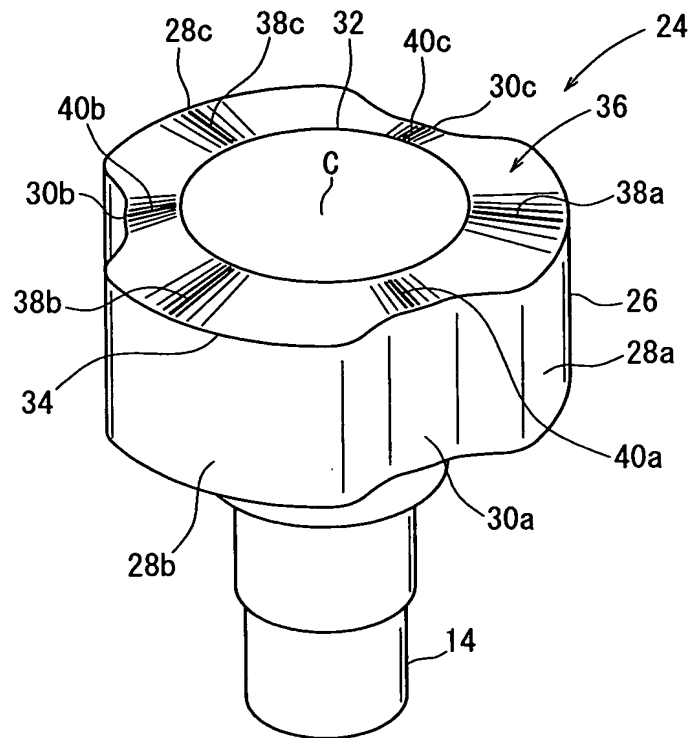


FIG. 11

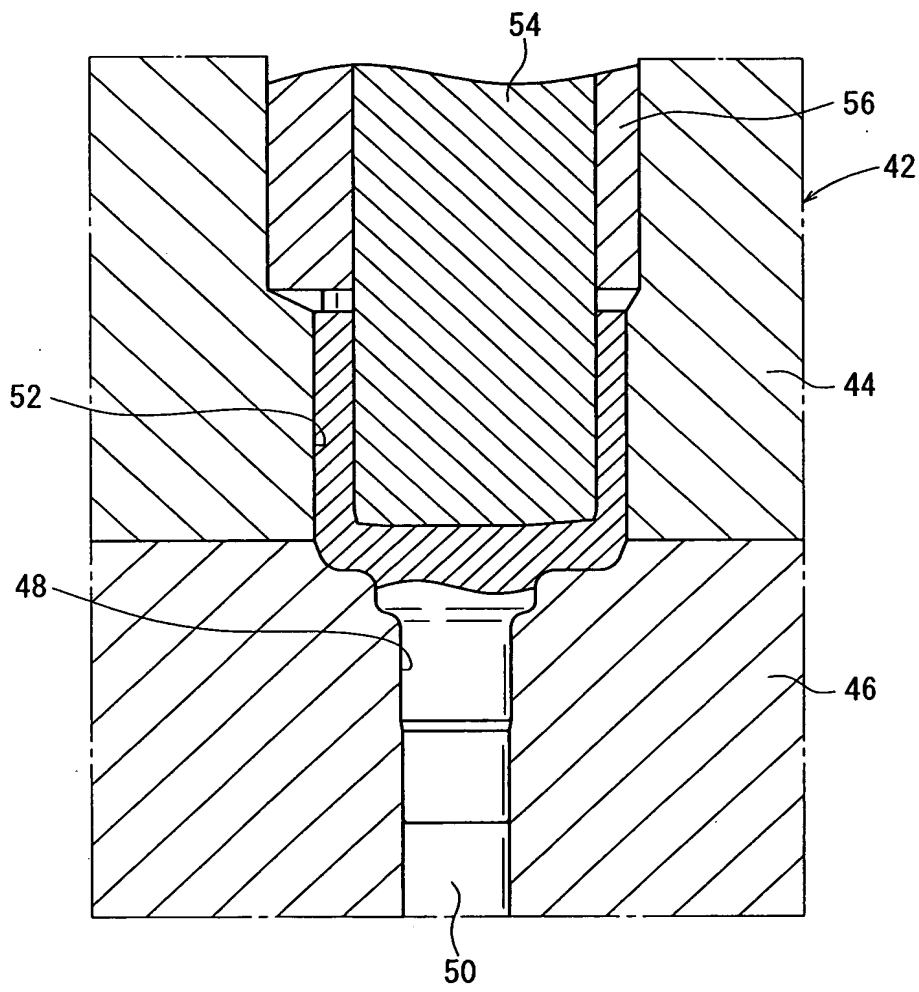


FIG. 12

LARGER-DIAMETER PORTIONS (α)	SMALLER-DIAMETER PORTION (β)	ANGLE DIFFERENCE	HOW MATERIAL IS FILLED	FORMED BODY IN NEXT STEP	JUDGEMENT
3°	3°	0°	Δ	PROBLEM IN PLACING FORMED BODY IN DIE	Δ
	6°	3°	\bigcirc	NO PROBLEM	\bigcirc
	9°	6°	\bigcirc	NO PROBLEM	\bigcirc
	10°	7°	\bigcirc	NO PROBLEM	\bigcirc
	12°	9°	\bigcirc	NO PROBLEM	\bigcirc
	15°	12°	\bigcirc	NO PROBLEM	\bigcirc
	18°	15°	\odot	MATERIAL CRACKING	\times

FIG. 13

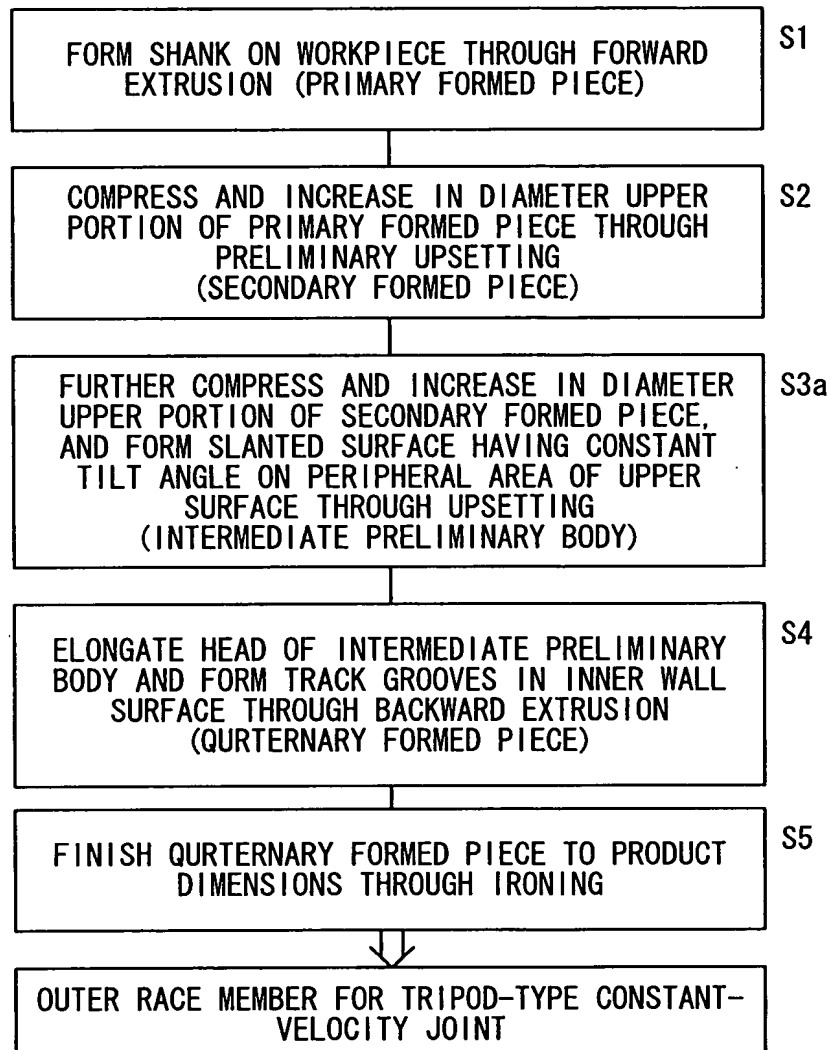
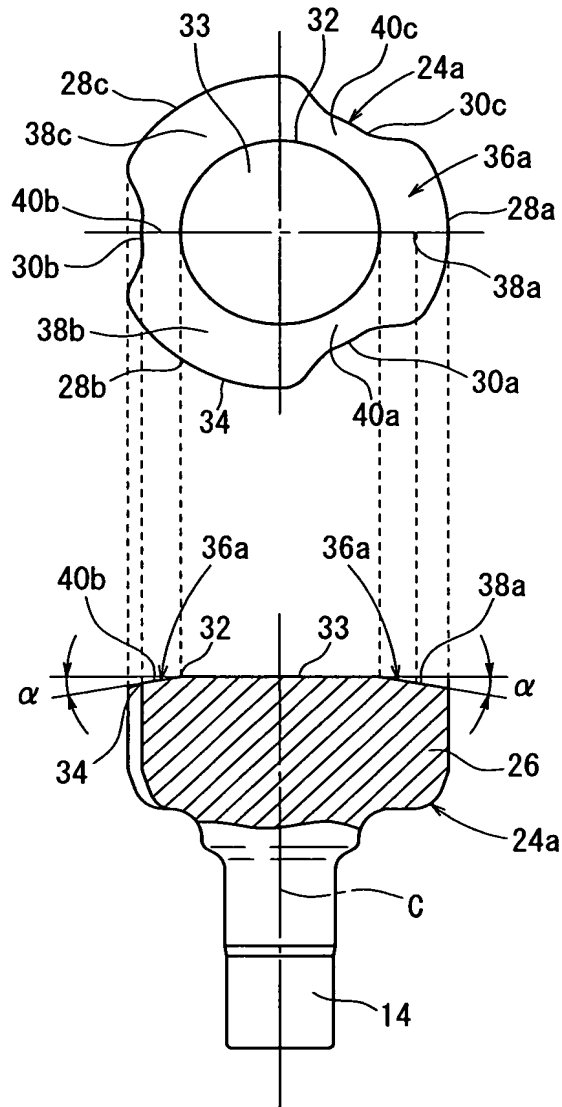


FIG. 14



(INTERMEDIATE PRELIMINARY BODY)

FIG. 15

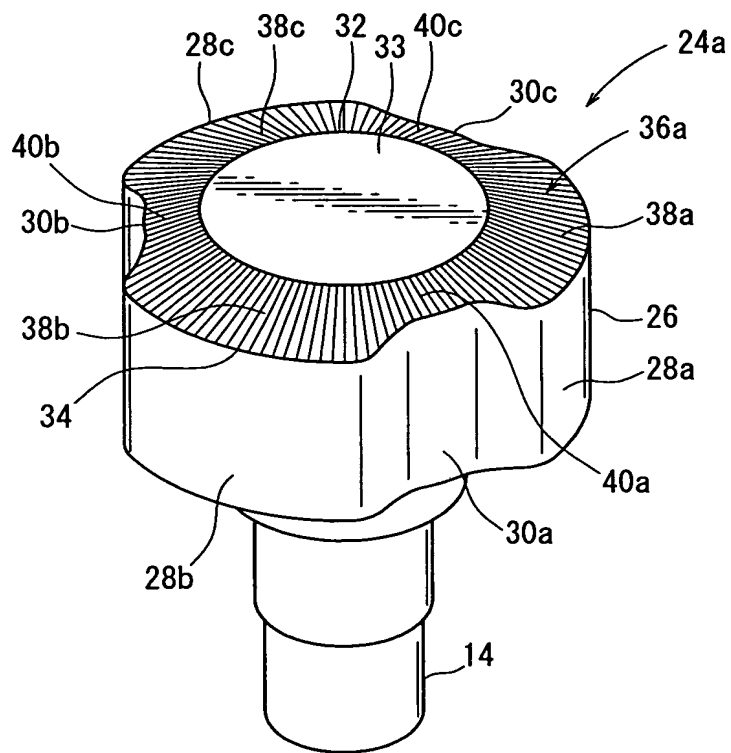


FIG. 16

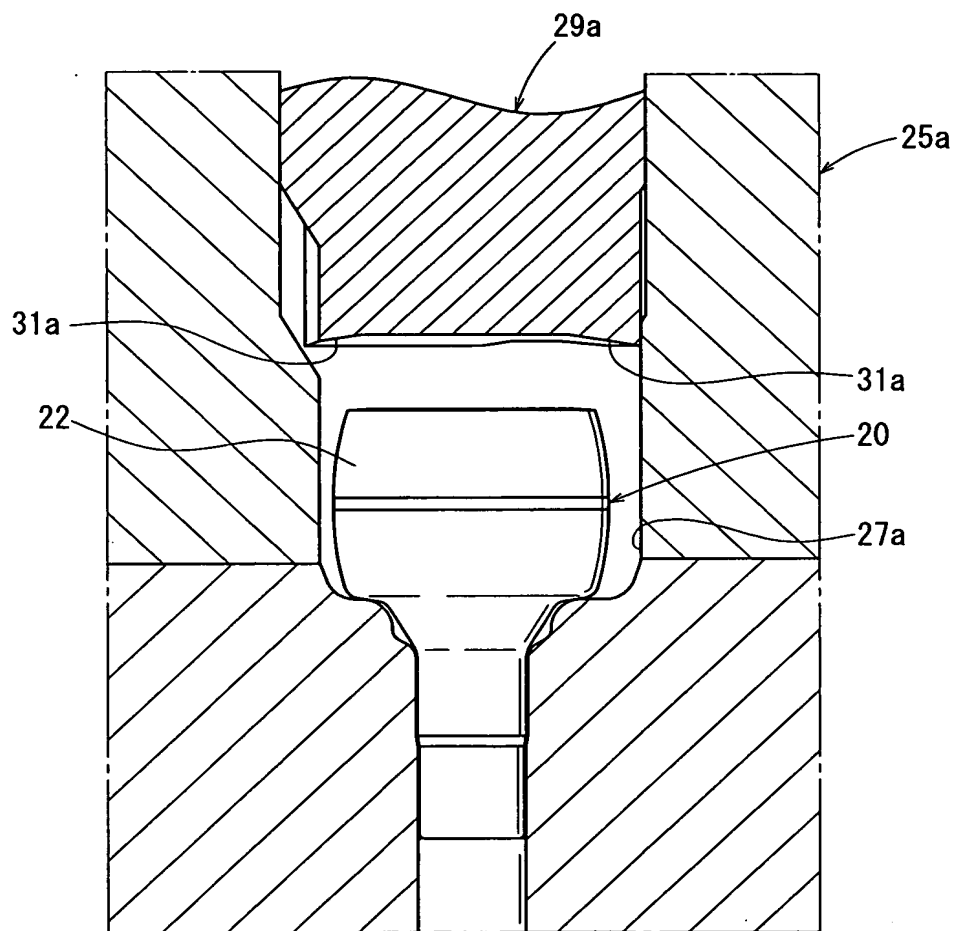


FIG. 17

